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RBE1X53-166-817-1
Job Sheet 189498



Part No: RBE1X53-166-817-1

Job Qty: 4 pcs

Part Name: Base Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/25/19

Job Tracking No:

Due Date: 2/28/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE1X53-166-817 Rev.2 IPP Rev. A 19.01.07 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	4 pcs		2/28/19	0.00	0.80	Waterjet - Omax		de 19/02/02
110	QC 2	4 pcs		2/28/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

SCRAP

P.T.O.

				QC 2 - 8	
120	Conventional Mill - 1	4 pcs	2/28/19	0.00 0.00	Conventional Mill - 1 - B4B
					Conventional Mill - 2 - B4B
130	QC 2	4 pcs	2/28/19	0.00 0.00	QC 2 - 1
					QC 2 - 12
					QC 2 - 14
					QC 2 - 17
					QC 2 - 19
					QC 2 - 2
					QC 2 - 20
					QC 2 - 22
					QC 2 - 23
					QC 2 - 25
					QC 2 - 32
					QC 2 - 33
					QC 2 - 35
					QC 2 - 38
					QC 2 - 39
					QC 2 - 4
					QC 2 - 40
					QC 2 - 44
					QC 2 - 45
					QC 2 - 48
					QC 2 - 49
					QC 2 - 50
					QC 2 - 51
					QC 2 - 52
					QC 2 - 54
					QC 2 - 56
					QC 2 - 57
					QC 2 - 62
					QC 2 - 63
					QC 2 - 8
140	QC 8	4 pcs	2/28/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 38
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
150	Outsource - 12 - Black Oxide	4 pcs	2/28/19		GRO002-VC
160	Packaging 2-1 - Receive - B4B	4 pcs	2/28/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B

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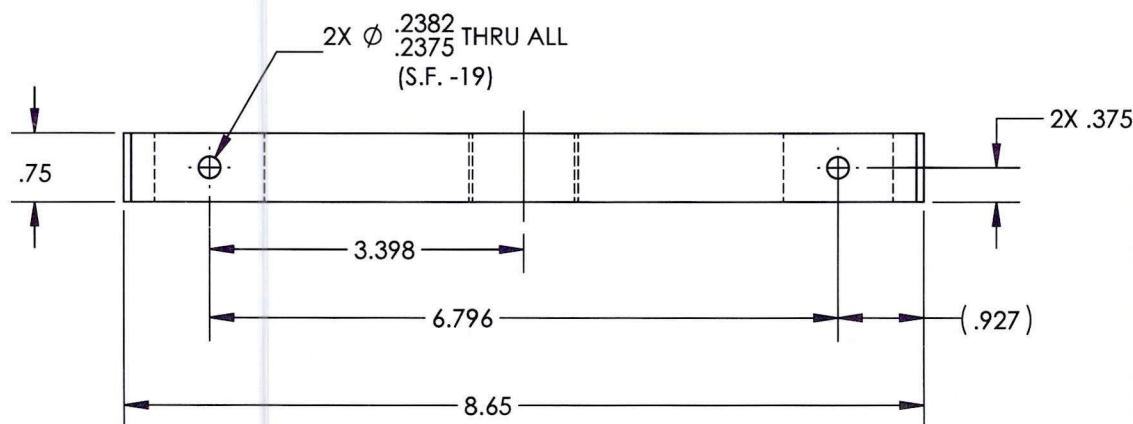
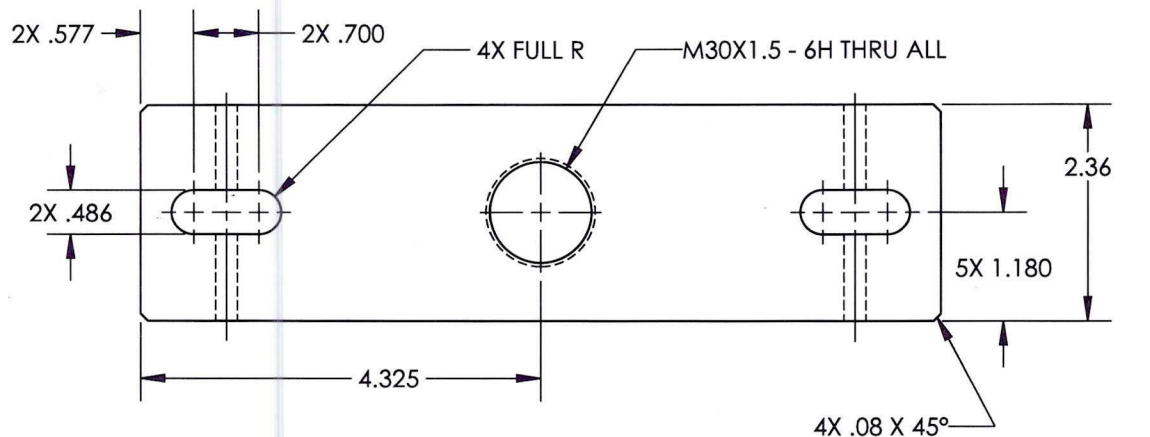
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
170 QC 6	4 pcs	2/28/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
180 Packaging 3-1 - Stock - B4B	4 pcs	2/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	

				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
190 QC 21 - SA	4 pcs	2/28/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
Part Op 100 - 1-Cut as per DWG. DWG. Rev: _____ PROG. Rev: _____ 2-Debur if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - 1-Machine as per DWG. 2-Debur 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 150 - -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required 160 - (Receive & Inspect for Damage & Mat'l Certs) -Certificate of Conformity is required 170 - (QC6- All purchased or subcontracted products) 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-HRS-P-0.750	Hot Rolled Steel Plate 0.750" (44W)	.5760 sf (.144 ea)	100-Waterjet - Omax - 1		
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Omax - 1	MT-HRS-P-0.750	1	5	0	
Part Specifications					
Specifications could not be found.					

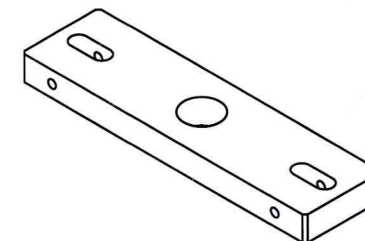
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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2	16-0220	-1 CH'D DIM WAS 2X Ø .2362/.2358 THRU ALL IS 2X Ø .2382/.2375 (S.F. -19), WAS 8.650 IS 8.65, WAS 2.360 IS 2.36, WAS .750 IS .75, CH'D MATERIAL WAS 1018 IS A36/1018/1020 HR, ADDED FINISH QMSI-6.2.2, B.O. REV D.	11/14/2016	RJC
				SM



(1)
BASE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189498 M5
19-01-25

DART AEROSPACE	
TITLE PULLER	
DWG NO. RBE1X53-166-817-1	REV 2
MAT'L A36/1018/1020 HR HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	USED ON MODEL
CHECKED: DUERFELDT	EC135
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE 1:8	DATE 6/15/2012
SHEET 2 OF 7	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S151290



Part: RBE1X53-166-817-1

Job No: 189498

Serial No/Batch: S151290

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 02/06/19

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>189498</u> Part No. <u>RBE1X53-166-817-1</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☒ Supplier ☐ Quality ☐					
Date : MAR 07 2019		Sequence #: <u>110 QC2</u>		QTY Affected : <u>4</u>			MRB (QSI042)		
Description Work Order Deviation				Disposition				Completed By DAS 68 MAR 07 2019 Lead hand / Supervisor <u>A. 19-03-07</u> QC / QA Coordinator DAS 68 9-89 MAR 07 2019	
<u>- HOLES CUT IN PARTS BY WATER JET ARE TAPERED BEYOND REPAIR.</u>				<u>- SCRAP</u>					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							